

Date: Tuesday, 09/06/2009 2:32:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET LID, RH)
Job Number : 48441	
Estimate Number : 13663	
P.O. Number :	Part Number : D3836042
This Issue : 09/06/2009 S.O. No. :	Drawing Number : D3836 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 46089	Material :
Written By :	Due Date : 15/06/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JD 09.06.09</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:eC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: 344274

Cpl 09.06.11

✓ 2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 1.8698 f(s)/Unit Total : 3.7397 f(s)

304 SQ Tube .75x.75x.065W

batch: M11148

SAD 09-06-09

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAD 09-06-09

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

(092)
 509/06/11 (72)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

1- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: M106762

Cpl 09-06-11

(22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/06/2009 2:32:18 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 48441

Part Number: D3836042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- grind weld flush where indicated on dwg D3836
4- deburr if necessary

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-06-11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 11 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-06-11 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11 *MF*

Job Completion



MF
09-06-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

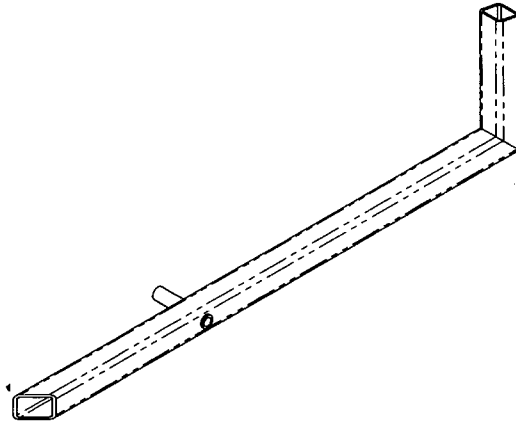
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

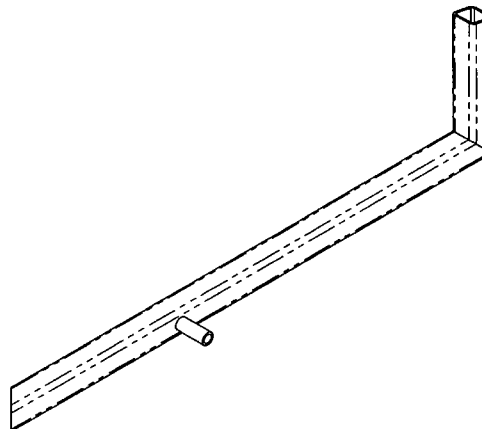
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



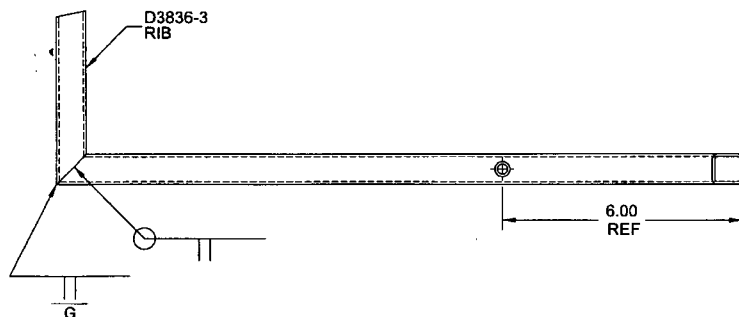
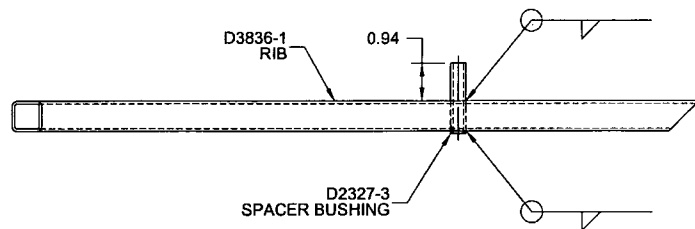
D3836-041 RIB ASSY (BASKET LID, LH)

NO. *WORK ORDER*
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY

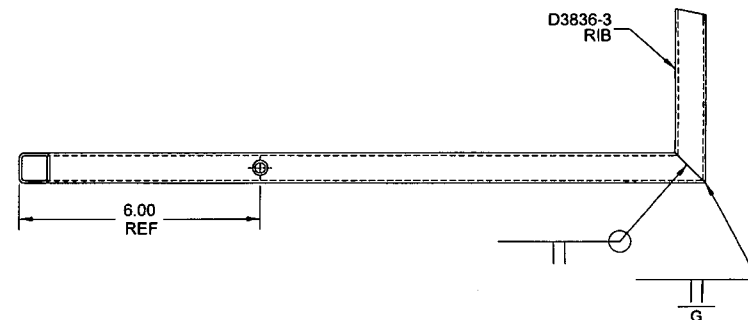
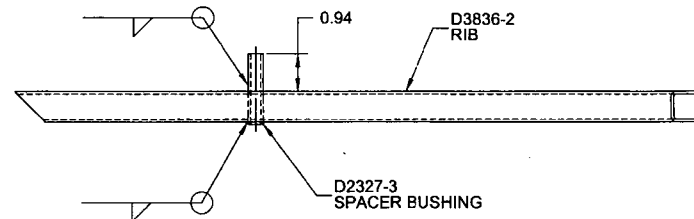
- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

RELEASED
08/09/24 MP

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS-3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D3836	SHEET 1 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3836-041 RIB ASSY (BASKET LID, LH)



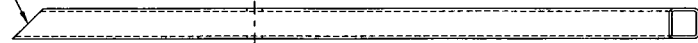
D3836-042 RIB ASSY (BASKET LID, RH)

WORK COPY
 NOT FOR
 CONSTRUCTION
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 WITHOUT NOTICE
 ORDER

RELEASED

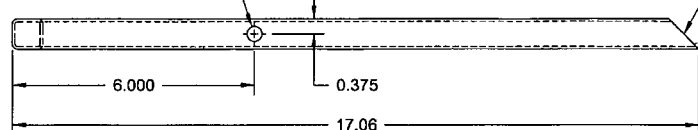
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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0.75 X 45°
CHAMFER

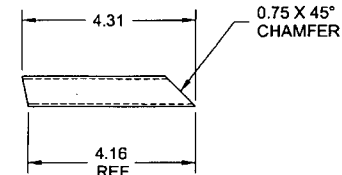


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER

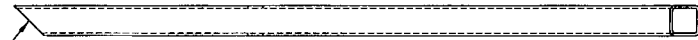


D3836-1 RIB



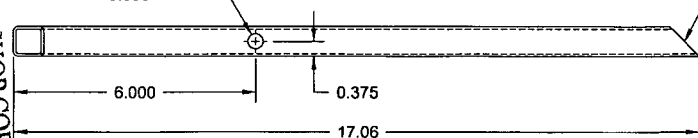
D3836-3 RIB

0.75 X 45°
CHAMFER

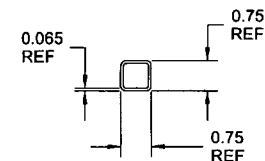


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

STOP COPY
FOR INKING
TO AMENDMENT
CONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
10/2/84

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	AP	D3836	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	RIB ASSY (BASKET LID)	NTS
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